

Date: Tuesday, 7/1/2008 2:33:44 PM  
 User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ACCESS PANEL ASSEMBLY
Job Number	: 40184		
Estimate Number	: 13010		
P.O. Number	:	Part Number	: D3245043
This Issue	: 7/1/2008 S.O. No. :	Drawing Number	: D3245 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 35664	Material	:
Written By	:	Due Date	: 7/28/2008
Checked & Approved By	: <u>08.07.01</u>	Qty:	Um: Each
Comment	: Est Rev: A New Issue 07-09-11 JLM Verified By: EC Est Rev: b ECN 1052 07-10-31 DD verified by:		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0 D32453 Door



GA



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)  
 Door  
 Batch: B 36401 B 40201

qty 2  
 qty 6

8/07/09/03 (8)

8/08/09/03 (2)

3.0 D32457 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)  
 Gasket  
 Batch: 35668

88

8/09/02 (8)

4.0 235120009C3Y STUD



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)  
 STUD  
 Batch: M166484 x

88

8/09/02 (8)

5.0 127H35 HALF GROMMET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)  
 HALF GROMMET  
 Batch: M18245

88

8/09/02 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:44 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 40184

Part Number: D3245043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Studs and Gromets as per Dwg D3245

3-Bond Gasket using 3M ADHESIVE as per Dwg D3245

A/R 3M 1300/1300L ADHESIVE

Batch:

M10P891

08/08/04 (8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/04 (X8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P# and B# using fine point permanent ink marker and Stock

Location:

ST 182

08/09/05 (X8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10 (X)

Job Completion



mf 08-09-08

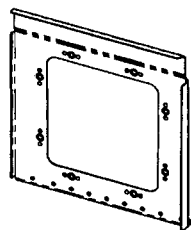
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

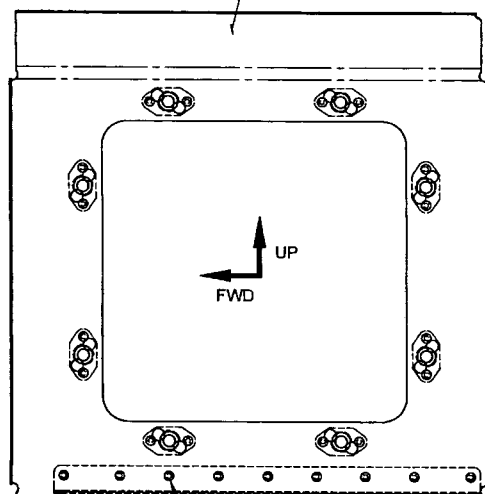
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-041 ACCESS PANEL ASSEMBLY**

**RELEASED**  
07-10-23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLY IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

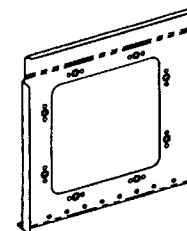
0.032  
GAP

D3245-5  
ANGLE PLATE

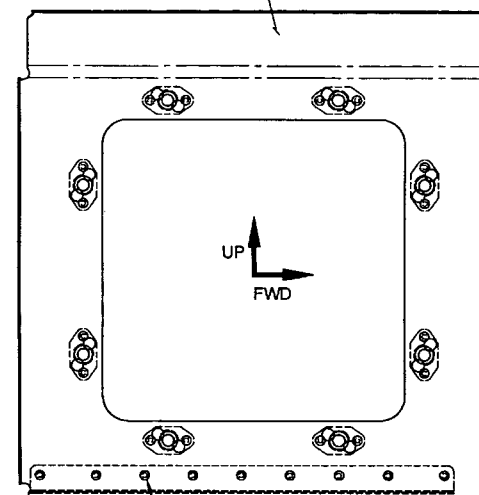
2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-5  
ANGLE PLATE

0.032  
GAP



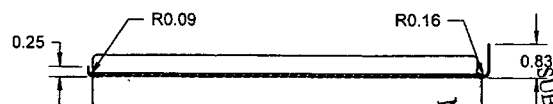
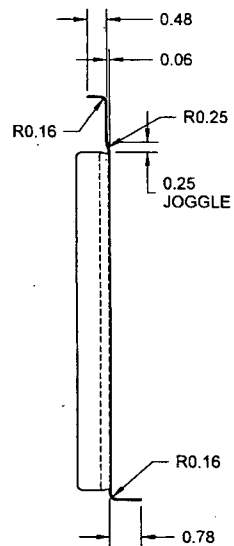
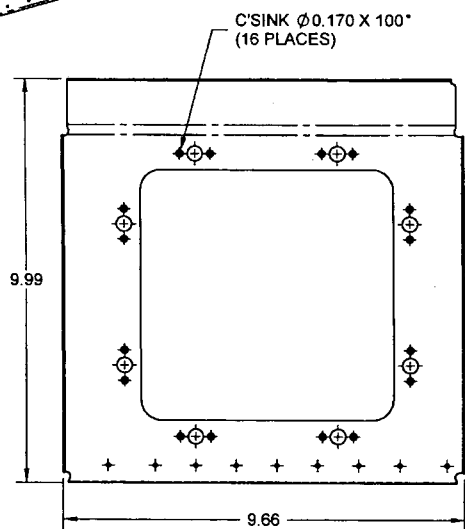
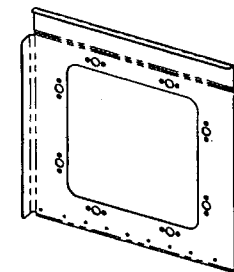
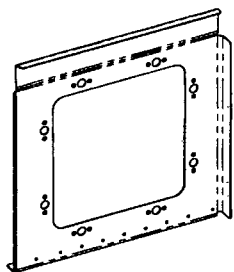
D3245-2  
PANEL



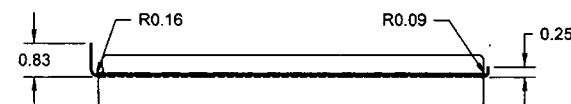
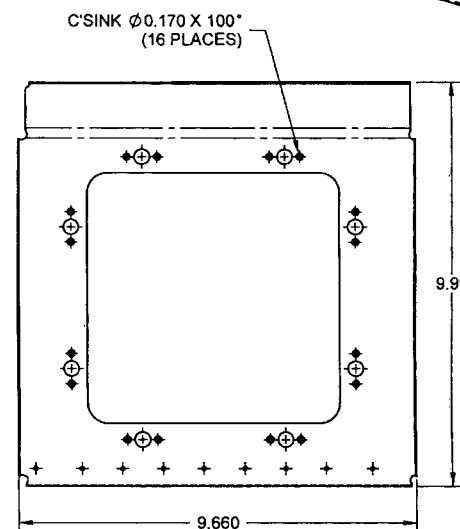
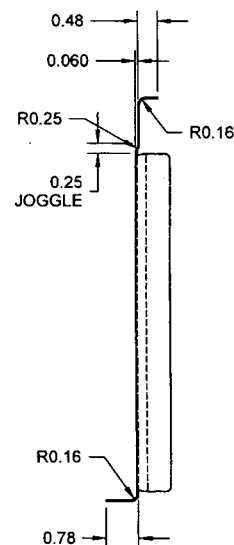
MS20615M3-3 RIVET  
(9 PLACES)

**D3245-042 ACCESS PANEL ASSEMBLY**

B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F. REMOVE MS21050-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3245</b>	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>ACCESS PANEL ASSEMBLY</b>	1:2.5
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**D3245-1 PANEL BEND DETAIL, LH**



**D3245-2 PANEL BEND DETAIL, RH**

**RELEASED**  
10-10-23

- NOTES:  
 1) MATERIAL: MAKE FROM D3245-1  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.70 lbs

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DRAWN	<del>B</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>DS</del>	D3245	SHEET 2 OF 7
APPROVED	<del>DS</del>	TITLE	SCALE
DE APPR.	<del>TH</del>	ACCESS PANEL ASSEMBLY 1:3	
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8 7 6 5 4 3 2 1

D3245-5 DOOR  
2351-20-009-C3Y STUD (1)  
127H-35 GROMMET (1)  
(8 PLACES)

D3245-7 GASKET  
(REF)  
8.00  
(TYP, REF)

INSTALL D3245-7  
GASKET ON THIS SIDE

# **D3245-043 DOOR ASSEMBLY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

## **NOTES:**

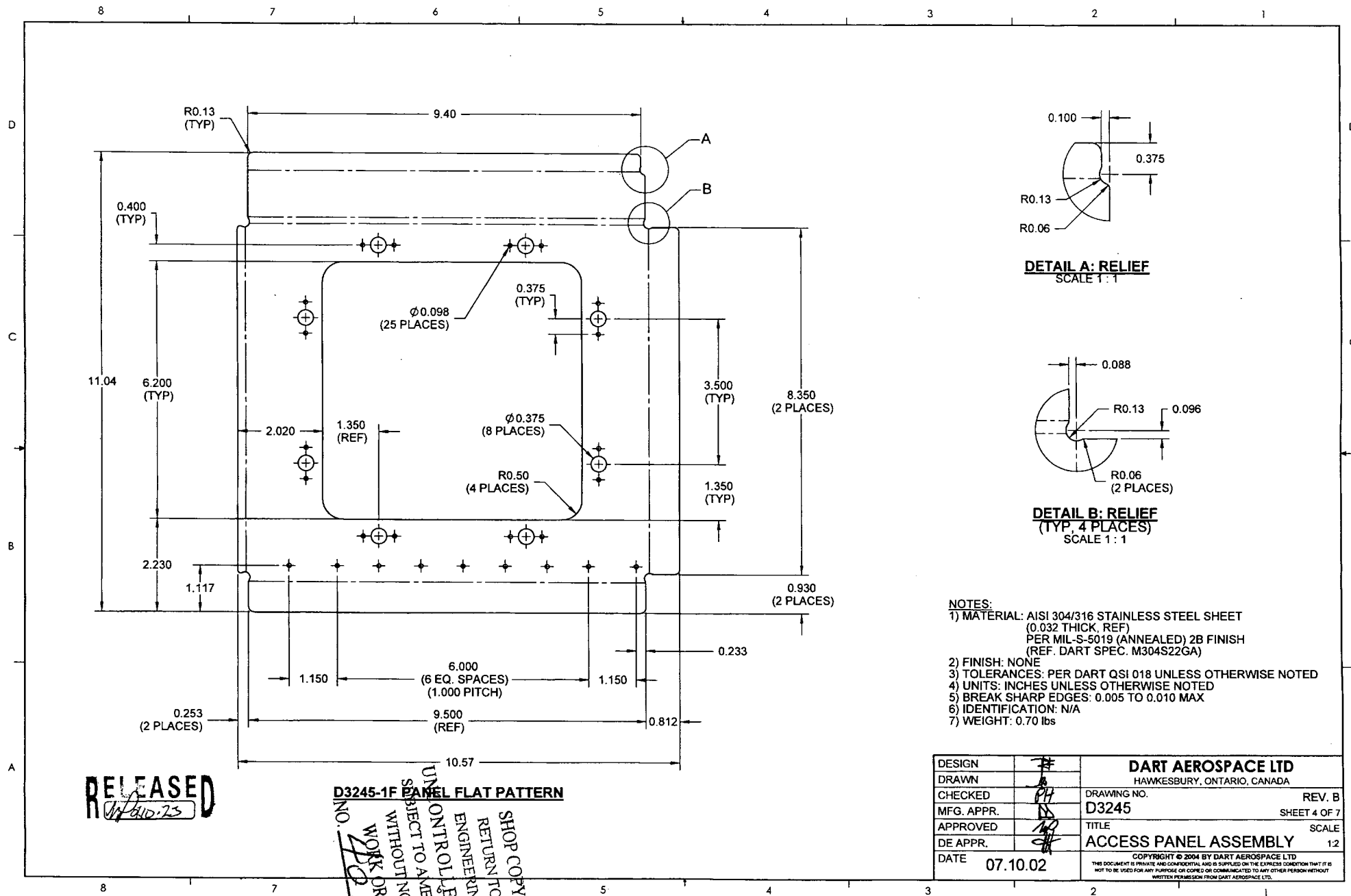
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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7.10.02

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MFG. APPR.	PH	D3245	SHEET 3 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY	1:2
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8 7 6 5 4 3 2 1





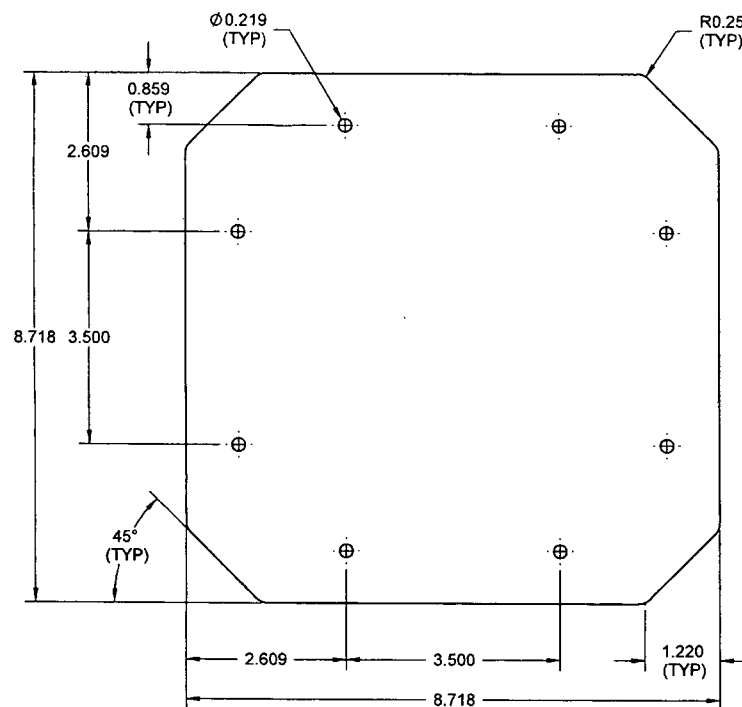
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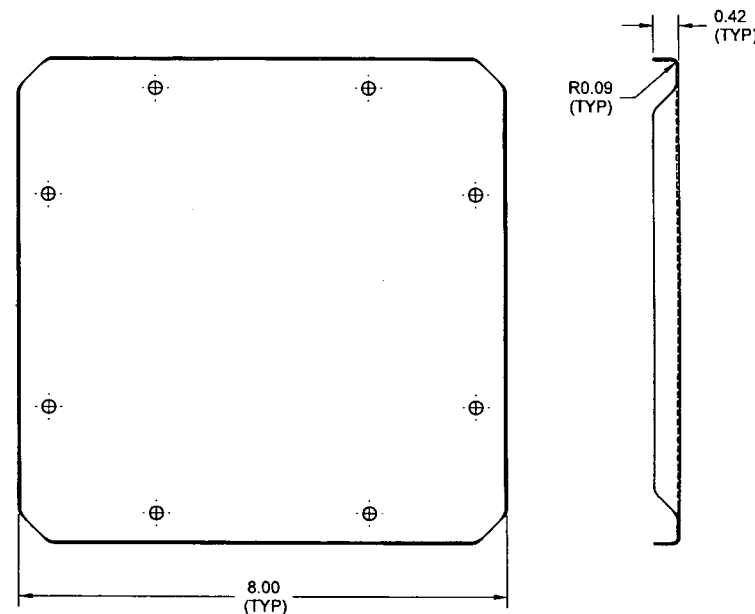
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B

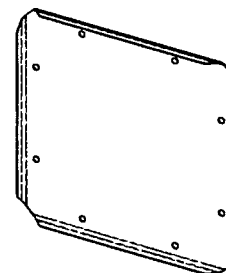
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**D3245-3P DOOR FLAT PATTERN**



**D3245-3 DOOR BENDING DETAIL**









**RELEASED**  
07.10.02

**NOTES:**

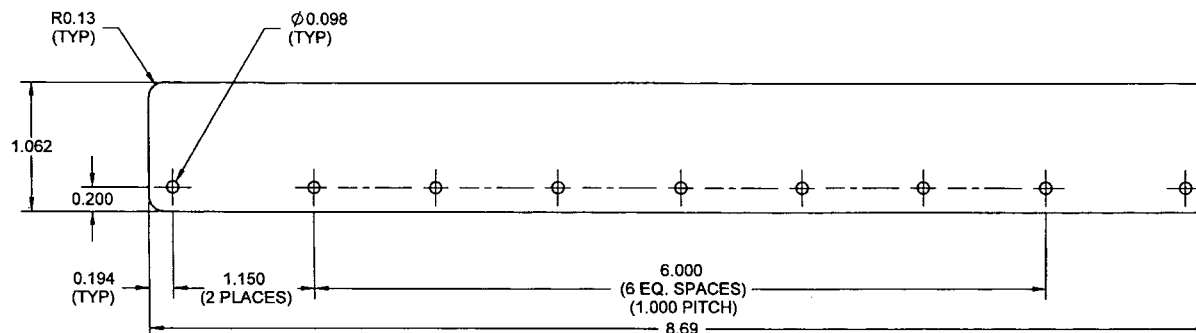
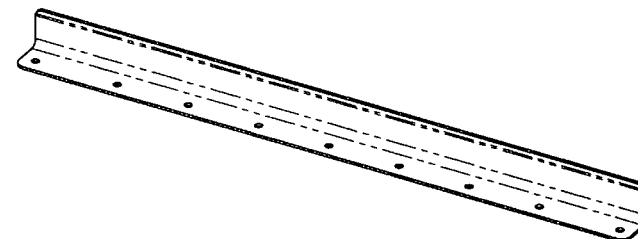
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

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NO. 10187

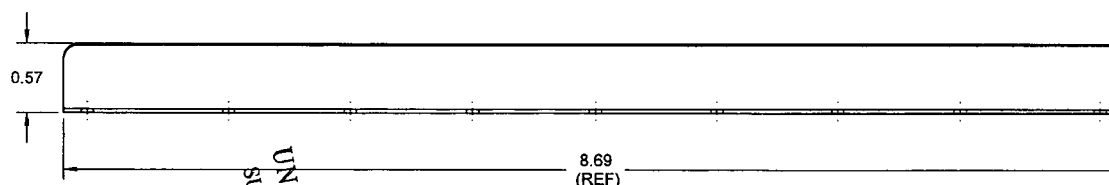
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3245	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>ACCESS PANEL ASSEMBLY</b>	
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

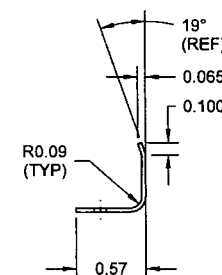
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**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL**  
(MAKE FROM D3245-5F)



**RELEASED**  
07.10.23

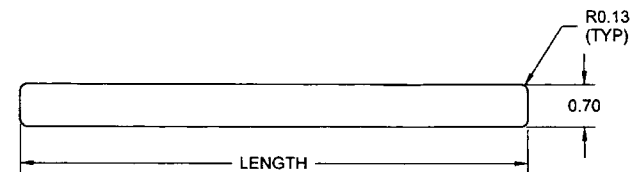
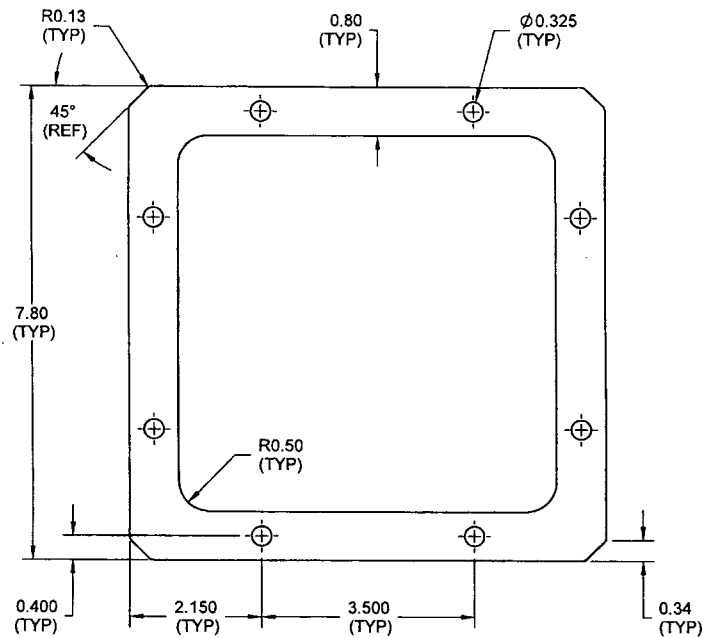
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**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<del>TH</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>TH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>TH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>TH</del>	D3245	SHEET 6 OF 7
APPROVED	<del>TH</del>	TITLE	SCALE
DE APPR.	<del>TH</del>	<b>ACCESS PANEL ASSEMBLY</b>	
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8 7 6 5 4 3 2 1



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**D3245-7 GASKET**

NO. 40184  
WORK ORDER  
SUBJECT TO AMENDMENT  
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RELEASED  
07.10.02

**NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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CHECKED	<del>PH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>PH</del>	D3245	SHEET 7 OF 7
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	ACCESS PANEL ASSEMBLY	1:2
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